

Ship Nov. 12

Work Order ID 62558



Page 1

Monday, October 04, 2010 10:59:55 AM

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop



Start Date: 10/4/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 11/10/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-10-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

8 10/4/08

Hj for BG 10-11-05

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R ☐ Aluminum Rod *M108436*
M114877

3-Grind End Plate flush

10-10-07 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 10/4/2010 Start Qty: 5.00

Cust Item ID:

Required Date: 11/10/2010 Req'd Qty: 5.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				5	0	BE10/10/28	
130  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				8	10/10/28		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				27	10/10/29		

W/O:		WORK ORDER CHANGES					
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Required Date: 11/10/2010 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10.11.01

5

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R ☐ Aluminum Rod M108436

6-Grind End Plate flush

7-Install last rivet as per Dwg.

10.11.01

5

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Start Date: 10/4/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 11/10/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				5	0	BE10/11/02	
200 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8 similar					
210 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				5		10/11/2	

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 11/10/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M115791</i> Memo START TIME: <i>7:35</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>8:05</i>	0.00 0.00				<i>5</i>		<i>BR 10-11-5</i>	
230 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>M115790</i> Memo	0.00 0.00				<i>5</i>		<i>BR 10-11-8</i>	
240 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>=> 90</i>	<i>10/11/08</i>		<i>5</i>	<i>0</i>		

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Cust Item ID:

Required Date: 11/10/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-311 Location: _____								

10/11/05

810/10/04

45
40

ReoB

10/11/05

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/09 *[Signature]*
MF
10-11-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Monday, October 04, 2010 10:59:58 AM

Page 1

Work Order ID: 62558

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH




Start Date: 10/4/2010

Required Date: 11/10/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3272-1 JLM
 IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
 IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3067-1  End Plate		Manufactured	No			110	Each	72.0000	1	5			
<div> <div>Location</div> <div>WA</div> <div>60141</div> </div> <div> <div>Loc Qty</div> <div>72</div> <div>72</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3219-1  Plate		Manufactured	No			110	Each	141.0000	2	10			
<div> <div>Location</div> <div>WA</div> <div>60859</div> <div>61204</div> </div> <div> <div>Loc Qty</div> <div>141</div> <div>27</div> <div>114</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3272-1  Step		Manufactured	No			110	Each	15.0000	1	5			
<div> <div>Location</div> <div>WA</div> <div>362533</div> <div>62134</div> </div> <div> <div>Loc Qty</div> <div>15</div> <div>15</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

10.10.27

5

10.10.27

10

10.10.22

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 10/4/2010

Required Date: 11/10/2010

Start Qty: 5.00

Required Qty: 5.00

D3065-041

Manufactured No

180 Each

53.0000 1



Step Leg Assembly Hi

5
10-11-01

Location

Loc Qty

Loc Code

WA

53

60200

14

61216

39

D3066-1

Manufactured No

180 Each

83.0000 2



Spacer

5
10
10-11-01

Location

Loc Qty

Loc Code

WA

362662

83

60194

35

61205

48

D3067-1

Manufactured No

180 Each

72.0000 1



End Plate

5
9
10-11-01

Location

Loc Qty

Loc Code

WA

362664

72

60141

72

MS20600-AD4W4

Purchased No

180 Each

1,699.000 16



Rivets

80
10-11-01

Location

Loc Qty

Loc Code

ST321

1699

113368

62

114181

11

114718

2

115573

624

115640

1000

80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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Start Date: 10/4/2010

Required Date: 11/10/2010

Start Qty: 5.00

Required Qty: 5.00

AN3-35A Purchased No 250 Each 90.0000 2  10/11/55

 Bolt

Location	Loc Qty	Loc Code
ST353	90	
115108	40	
115457	50	

AN4-13A Purchased No 250 Each 480.0000 8  40 10/11/55

 Bolt

Location	Loc Qty	Loc Code
ST358	480	
115159	480	

AN5-36A Purchased No 250 Each 97.0000 2  10 10/11/55

 Bolt

Location	Loc Qty	Loc Code
ST341	97	
114292	5	
114941	92	

AN960JD10 NAS1149D0363J Purchased No 250 Each 8.0000 4  20 11/5622 10/11/55

 Washer

Location	Loc Qty	Loc Code
ST	6	
107715	6	
ST335	2	
105792	2	

Monday, October 04, 2010 10:59:58 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 11/10/2010

Start Qty: 5.00

Required Qty: 5.00

AN960JD416 NAS1149D0463J Purchased No

250 Each

24.0000

16 - 80



Washer



M116025 10/11/58

Location

Loc Qty

Loc Code

ST300

24

113288

24

AN960JD516 NAS1149D0563J Purchased No

250 Each

34.0000

4 - 20



Washer



M114742 10/11/58

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

D2230-3 Manufactured No

250 Each

70.0000

4 - 20



Lug



B62660 10/11/58

Location

Loc Qty

Loc Code

ST476

70

55452

2

60846

68

D2618 Manufactured No

250 Each

83.0000

2 - 10



Bushing



10/11/58 (52)

Location

Loc Qty

Loc Code

ST019

81

60772

81

ST020

2

56892

1

57829

1

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 11/10/2010

Start Qty: 5.00

Required Qty: 5.00

D2856-400 x2 @ 7.2"

Manufactured No

250 f

276.3760 0.6 3



Abraison Strip

→ measure
6.0x1.0x0.5



10/11/55

Location

Loc Qty

Loc Code

ST403

276.3760421

56626

63.2560421

59920

213.12

Manufactured No

250 Each

57.0000 2 10

D3235-1



Mounting Lug



B61845 10/11/55

Location

Loc Qty

Loc Code

ST471

57

60490

17

60851

40

Manufactured No

250 Each

57.0000 1 5

D3278-041



Support Assembly



10/11/55

Location

Loc Qty

Loc Code

ST471

57

60201

17

61212

40

Purchased No

250 Each

1,720.000 2 10

MS21042L3



Nut



10/11/55

52

Location

Loc Qty

Loc Code

ST300

1720

114523

49

114784

1671

70

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 11/10/2010

Start Qty: 5.00

Required Qty: 5.00

MS21042L4

Purchased

No

250

Each

4,434.000

8

40



10/11/5 sl

Nut

Location

Loc Qty

Loc Code

ST300

4434

113422

68

114523

8

114718

16

114784

32

115108

1310

~~115589~~

1900

115621

1100

40

MS21042L5

Purchased

No

250

Each

899.0000

2

-10



10/11/5 sl 50

Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

873

~~115156~~

373

115594

500

70

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG SCALE NTS	
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *68558*

2010-10-04

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

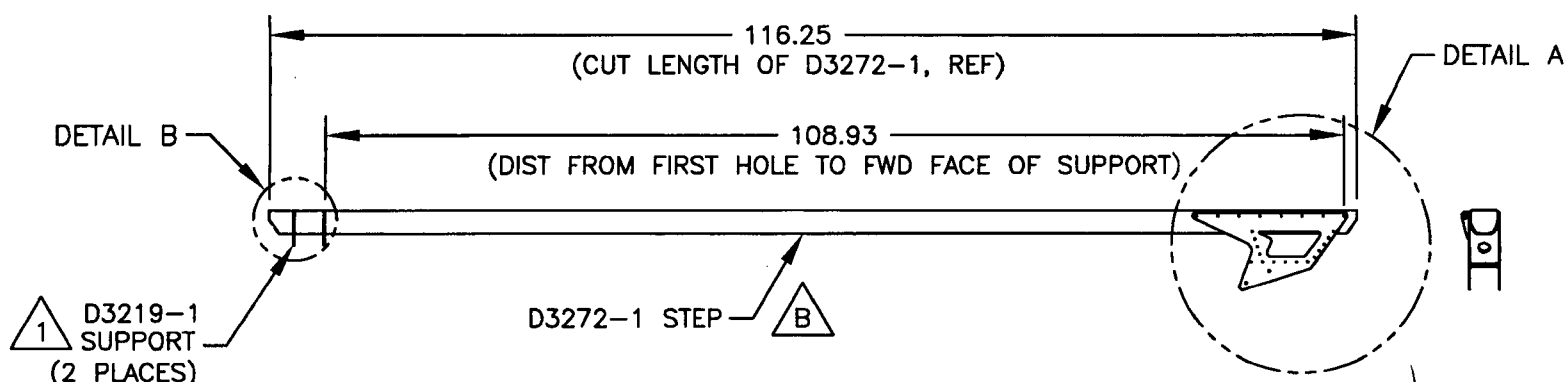
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

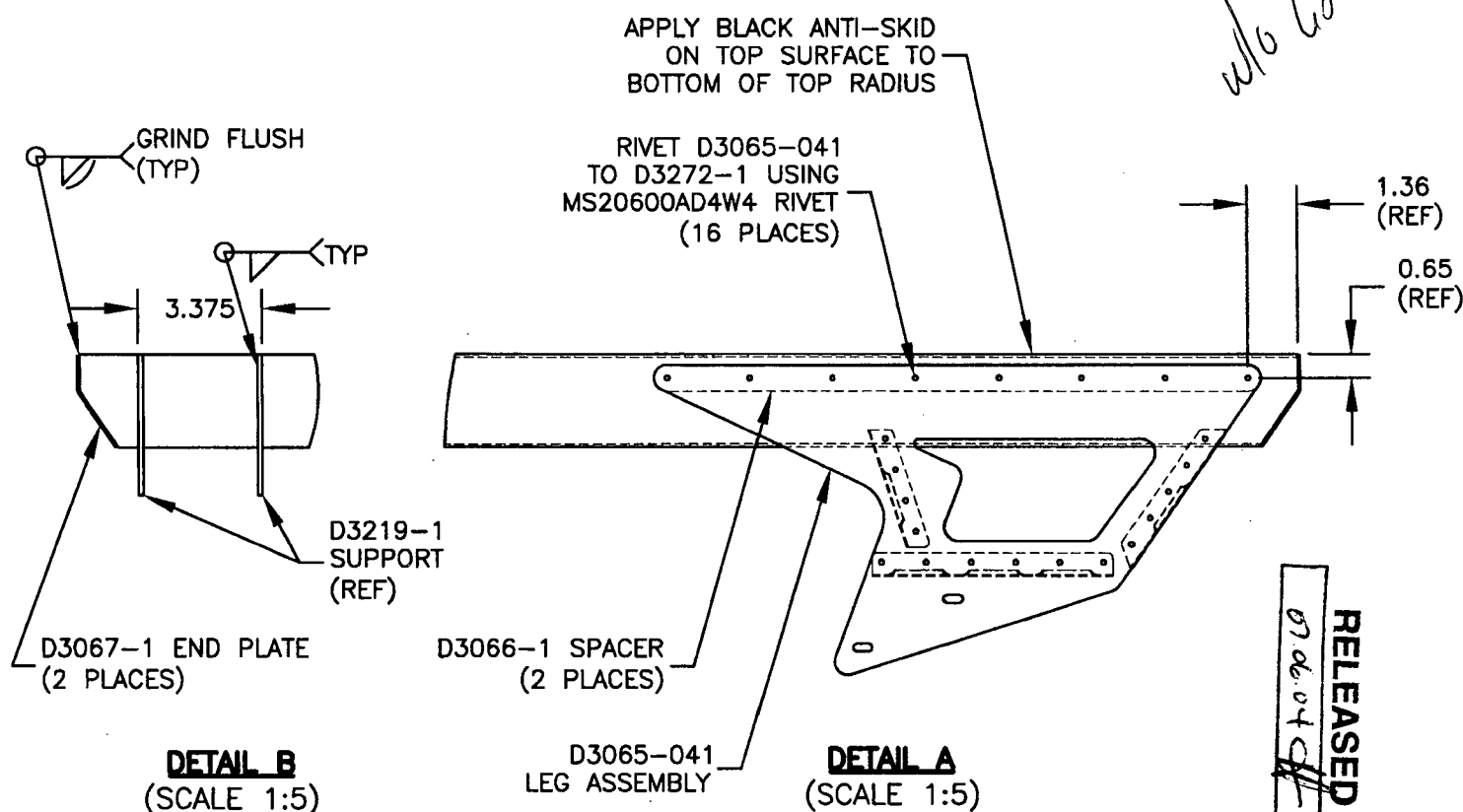
NOTE: Date & initial all entries



DESIGN 40	DRAWN BY J.B.	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED C.E.	APPROVED J.B.	REV. B
DATE 07.05.18	DRAWING NO. D3272	SHEET 2 OF 3
	TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

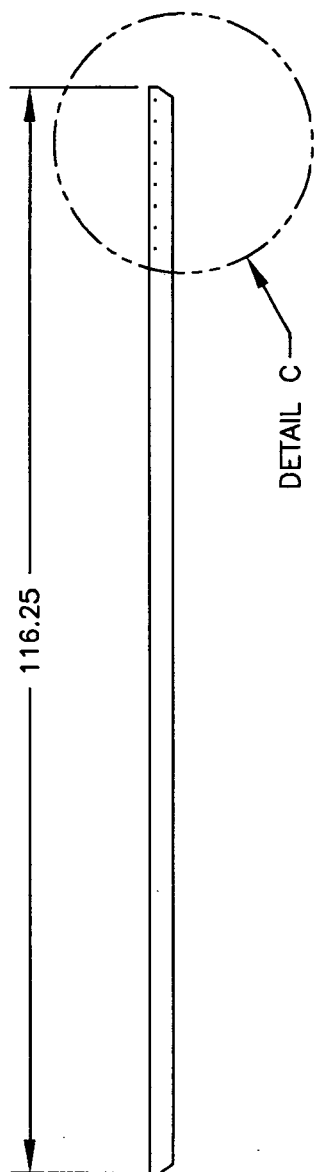
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

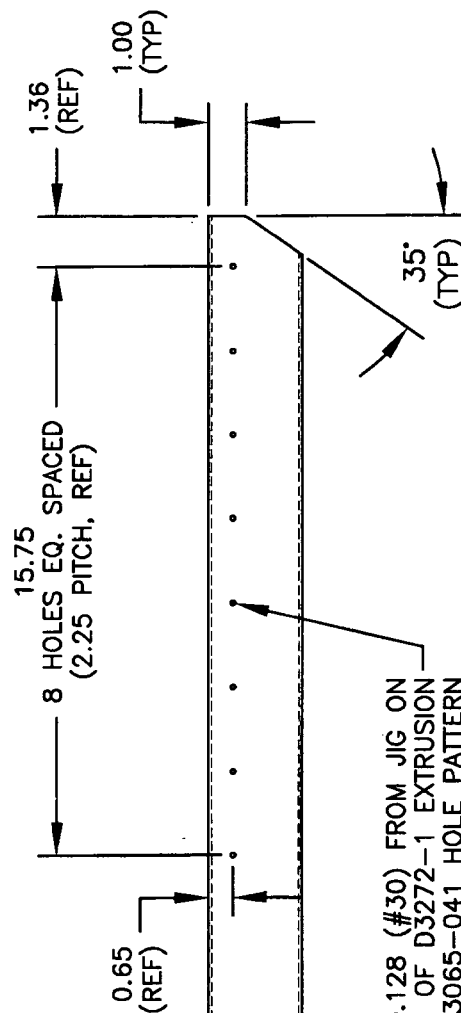


DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

RELEASED

07.06.04

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.